

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020603**Date Inspected:** 25-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Mr. Geng Wei		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No
<b>Weld Procedures Followed:</b>	Yes	No
<b>Verified Joint Fit-up:</b>	Yes	No
<b>Approved WPS:</b>	Yes	No
<b>Delayed / Cancelled:</b>	Yes	No

**Bridge No:** 34-0006**Component:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A.DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 14

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Diaphragm Plate identified as DP3105-001 weld number(s) 035 and 042. Welder is identified as welder no. 067949. The welding variables recorded by ZPMC QC identified as Zhong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U4b-F.

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Diaphragm Plate identified as DP3105-001 weld number(s) 094 and 102. Welder is identified as welder no. 068501. The welding variables recorded by ZPMC QC identified as Zhong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U4b-F.

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FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Diaphragm Plate identified as DP3102-001 weld number(s) 254. Welder is identified as welder no. 068920. The welding variables recorded by ZPMC QC identified as Zhong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U4b-F.

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Diaphragm Plate identified as DP3104-001 weld number(s) 254. Welder is identified as welder no. 067036. The welding variables recorded by ZPMC QC identified as Zhong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U4b-F.

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Diaphragm Plate identified as DP3087-001 weld number(s) 009 and 016. Welder is identified as welder no. 044790. The welding variables recorded by ZPMC QC identified as Zhong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2233-ESAB

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Diaphragm Plate identified as DP3090-001 weld number(s) 039 and 042. Welder is identified as welder no. 217805. The welding variables recorded by ZPMC QC identified as Zhong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2233-ESAB

During random in process inspection of the Orthotropic Box Girder (OBG) Deck Plate member identified as DP3107-001 this QA observed a cracked tack weld on weld joint 105 joints identified as 2 and 3F fillets. This QA marked the cracked tack and informed ZPMC Quality Control (QC) identified as Mr. Zhong Guo Hui of this issue. Mr. Hui informed this QA that the cracked tacks would be corrected in a manner compliant with the contract documents.

This QA Inspector observed new weld metal being placed over an existing cracked tack weld as noted above, weld identified as DP3107-001-105. This condition did not appear to comply with the contract documents. This QA Inspector informed ZPMC QC identified as Mr. Zhong Guo Hui of this issue. Mr. Hui informed this QA that the new weld and existing cracked tack weld would be corrected in a manner compliant with the contract documents.

During random in process inspection of Orthotropic Box Girder (OBG) Deck Plate member identified as DP3107-001 this QA observed arc strikes. This QA marked the affected areas and informed ZPMC Quality Control (QC) identified as Mr. Zhong Guo Hui of this issue. Mr. Hui informed this QA that the arc strikes would be corrected in a manner compliant with the contract documents.

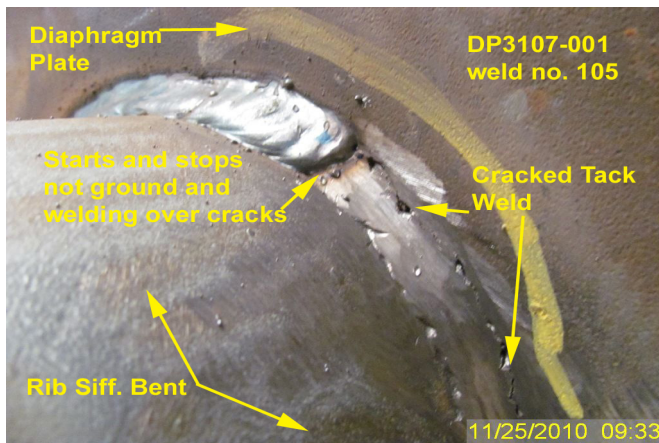
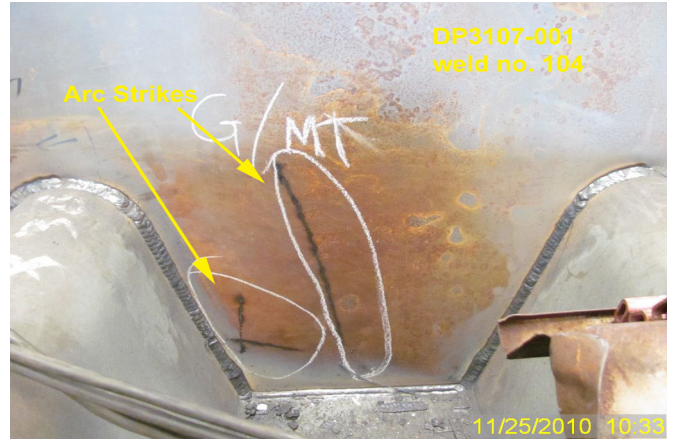
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

As mentioned above between QA and QC concerning this project

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

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**Inspected By:** DeArmond,Robert

Quality Assurance Inspector

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**Reviewed By:** Riley,Ken

QA Reviewer